

Work Order ID: ~~76504~~***76504***

Page 1

November-16-11 7:53:35 AM

Item ID: D3350-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Assembly

Start Date: 16/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 30/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 11/11/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3350

Rev A

100

0.00

100

BAND SAW


Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 0.750" x 0.750" x 15.00" long

 11/12/06

6

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

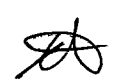
Memo

0.00

HAAS CNC vertical machine #1

Machine D3350-1 as per Folio FA496 and Dwg D3350 Identify as D3350-1

Manual Mill

 11/12/06

6

120

0.00

120

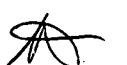
QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 11/12/07

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76504

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/11/2011 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 30/11/2011 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble and Deburr

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 76504

November-16-11 7:53:35 AM

76504

Page 3

Item ID: D3350-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Strut Assembly
 Start Date: 16/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 30/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

160

QC

Memo

0.00

Quality Control

6X J M / 11/12/08

170 Small Fab 0.00

170

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3350. Identify as D3350-041 and batch number using a fine point permanent marker

EP 11/12/09 (6)

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

8 11/2/09

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76504

76504

Page 4

November-16-11 7:53:35 AM

Item ID: D3350-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 16/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 30/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

190
 Powdercoat
 Powder Coating
 Memo
 START TIME: 8:15 OVEN TEMPERATURE:
 FINISH TIME: 8:45
 3200F
 6XØ m-f 11/12/14

200	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

200
 QC
 Quality Control
 Memo
 6 11-12-14

210	Identify as per dwg & Stock Location: 5271	0.00							
-----	--	------	--	--	--	--	--	--	--

210
 Packaging
 Packaging
 Memo
 6 Sp 11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

76504

Page 5

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

21424
Cu

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-16-11 7:53:40 AM

Page 1

Work Order ID: 76504

Parent Item: D3350-041

Parent Item Name: Strut Assembly

Start Date: 16/11/2011

Required Date: 30/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B05.07.11 Powder Coat now done after assembly KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A Bolt		Purchased	No			170	Each	40.0000	2	12		11/12/09	

Location

Loc Qty

Loc Code

ST351

40

114536

1

116786

39

AN960JD10

NAS1149D0363J

Purchased

No

Washer

170

Each

0.0000

4

24

D2324-5

Manufactured

No

Strap

170

Each

1.0000

2

12

Location

Loc Qty

Loc Code

GA

1

71596

1

M6061T6B0.750X00.750

Purchased

No

6061-T6 Bar .750 x .750

170

f

17.4200

1.2604

7.9604211

Location

Loc Qty

Loc Code

MAT003

17.42

114993

4.58

117379

8.84

119346

4

119801

8.

11/12/09

M119641

M117601

B76505

B76675

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-16-11 7:53:40 AM

Page 2

Work Order ID: 76504

Parent Item: D3350-041

Parent Item Name: Strut Assembly

Start Date: 16/11/2011

Required Date: 30/11/2011

Start Qty: 6.00

Required Qty: 6.00

MS21042L3
Nut

Purchased

No

110

Each

8,822.0000

2

12

CP 5/11/12/08

Location

Loc Qty

Loc Code

ST300

290

117441

16

117885

35

118451

5

118927

234

ST516

6000

119017

6000

ST518

2532

119075

2532

12

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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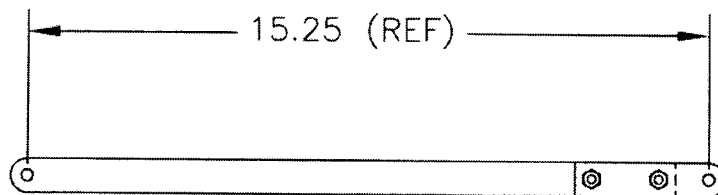
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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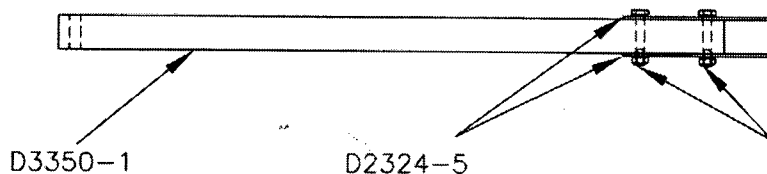


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	



SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76504 M.C.J

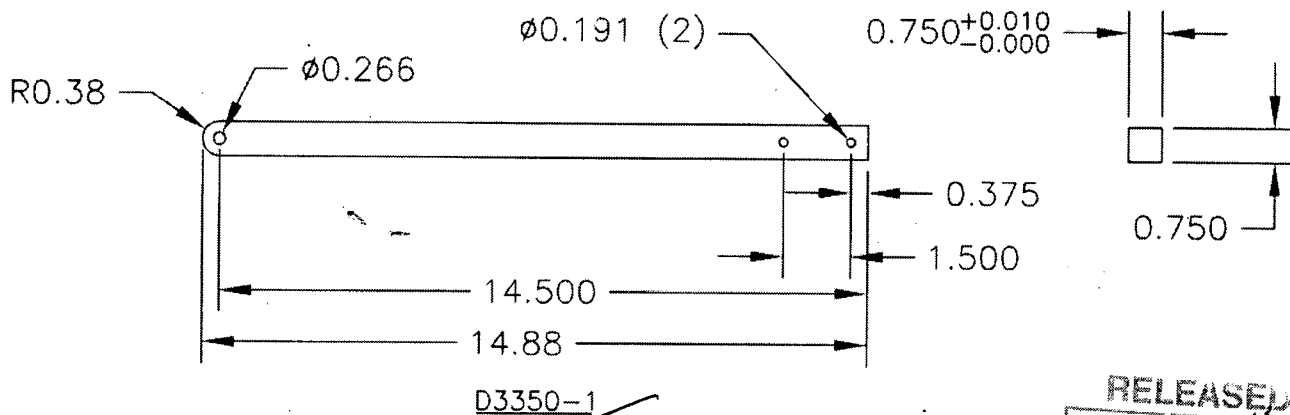
11/11/16



AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(TYP 2 PLACES)

D3350-041 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1 ✓

RELEASED
04.12.16

D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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